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THE REISING SUBMACHINE GUN, CALIBER .45, MODELS 50, 55, AND 60

I. RULES FOR CARRYING THE REISING SUBMACHINE GUN

Unless otherwise prescribed, the Reising submachine gun (with or without magazine) is habitually carried slung over the right shoulder, butt down, barrel to the rear, right hand grasping the sling, hand in front of armpit.

For marches and field exercises, the Reising submachine gun may be carried slung over either shoulder.

When troops are at ease, the piece is kept slung unless otherwise ordered.

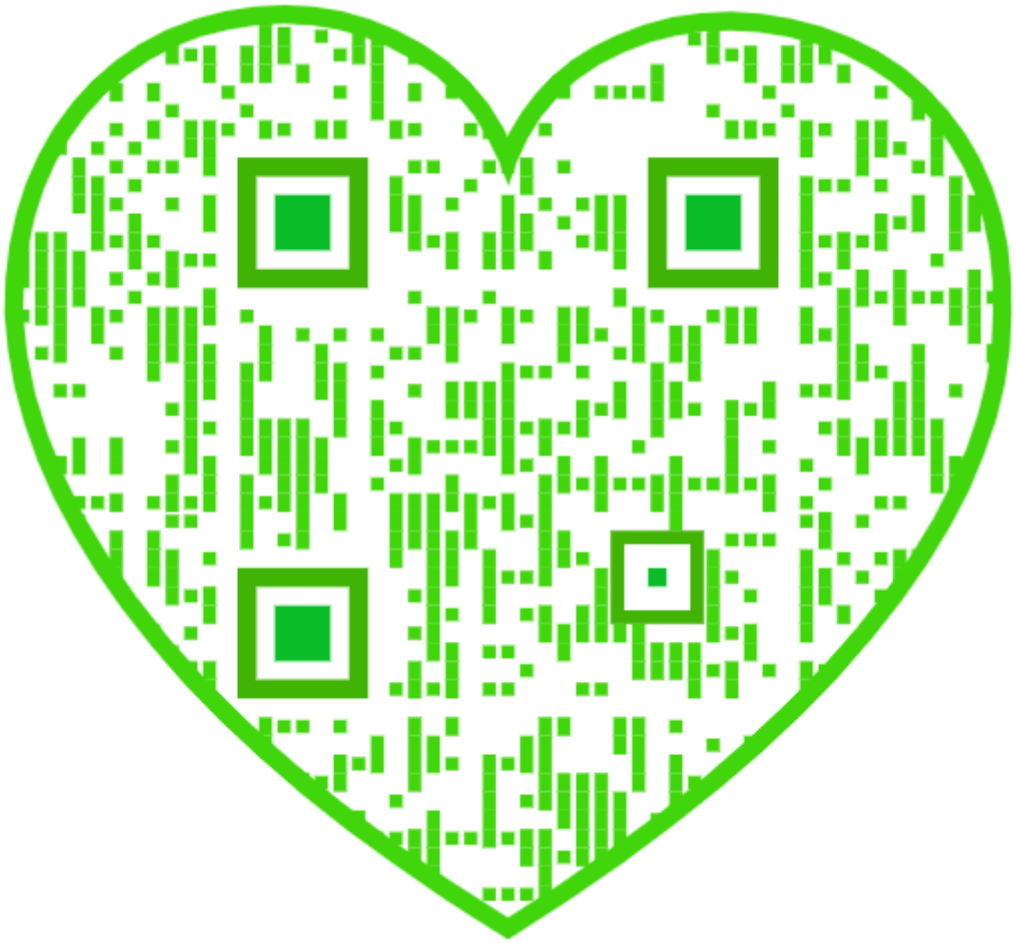
When troops are at rest, the piece may be unslung and held in any convenient position.

Only the following movements of the manual are executed by men armed with the Reising submachine gun.

(1) PARADE REST.—If at sling arms, execute as without arms keeping the right hand on the sling.

(2) INSPECTION ARMS:

Being at SLING ARMS, at the preparatory command INSPECTION, the left hand grasps the piece just below the magazine guide and carries the piece diagonally across the body. At the same time, the right arm is disengaged from between the sling and the weapon, the right hand grasping the small of the stock when the left hand is in front of the center of the body. The left hand then encircles the magazine, fingers to the front, thumb to the rear, thumb and forefinger pressing against the magazine catch. The magazine is withdrawn by the left hand and placed in the belt or pocket, and the piece is regrasped by the left hand just below the magazine guide. At the command of execution ARMS, the thumb of the left hand retracts the action bar, the fingers of the left hand grasping the piece when the action bar is fully retracted. Lower the head and eyes slightly and at the same time turn the piece sharply, barrel to the rear, sufficiently



to glance into the chamber. Having found no cartridges in the chamber, the piece is turned sharply barrel up, at the same time raising the head and eyes to the position of attention.

(3) Being at INSPECTION ARMS.—At the next preparatory command, release the action bar, pull the trigger, remove the magazine from the belt or pocket, insert in the piece, and regrasp the piece with the left hand just below the magazine guide. At the command of execution, execute SLING ARMS.

Men armed with the Reising submachine gun salute with the hand salute when not in ranks. In ranks, they do not salute.

II. DESCRIPTION

A. GENERAL

The Reising submachine gun, caliber .45, Model 50, 55, or 60, is an air-cooled, delayed blow-back, magazine-fed hand or shoulder weapon, which may be fired from any position and with one or both hands.

The exterior surface of the rear part of the barrel is made with radial flanges or cooling fins, which radiate the heat from the barrel during firing, thus cooling the barrel.

The type of fire is selective, either automatic or semiautomatic.

The weapon is fed from a box-type magazine, having a capacity of 20 rounds, and is intended for, and capable of, intensive fire against personnel within a range of 300 yards.

When a round is fired, the blow-back, delayed by the friction of cammed surfaces and the resistance of the action bar spring, is utilized to force the action bar and bolt to the rear, unlocking the bolt, extracting and ejecting the fired cartridge case, recocking the hammer, and compressing the action bar spring.

On termination of the rearward motion of the action bar and bolt, the action bar spring causes the action bar and bolt to move forward. During the forward motion, a cartridge is stripped from the magazine by the feed rib of the bolt and chambered. On termination of the forward motion, the weapon is loaded, the bolt locked, and the piece ready for firing.

The same mechanism is used in Models 50, 55, and 60. The model numbers indicate differences in stock or barrel length.

Model 50 is distinguished by its conventional rifle stock and by the addition of a compensator. This model is fitted with an 11-inch barrel and has the general appearance of a carbine.

Model 55 is distinguished by its folding steel stock which gives the weapon unusual compactness.

Model 60 is similar to Model 50 but is fitted with an 18-inch barrel, and is capable only of semiautomatic fire. It is not fitted with a connector.

B. OPERATION

The submachine gun is designed to fire cartridges, ball or tracer, caliber .45, M1911 or similar. The magazine holds 20 cartridges. Although more than 20 cartridges may be loaded into the magazine, such practice may result in a malfunction.

When the selector is set on "F. A." or "Full Automatic," the piece will fire as long as the trigger is depressed or cartridges remain in the magazine.

When the selector is set on "S. A." or "Semiautomatic," the piece will fire once each time the trigger is depressed and until the magazine is emptied.

When the selector is set on "Safe," the piece cannot be fired.

NOTE.—Before moving the selector from "F. A.," retract the action bar about one-fourth inch to allow connector to disengage from the action bar, should it be so engaged.

Magazines are inserted into the magazine guide and pressed upward until engaged by the magazine catch.

Magazines are released by pressing the magazine catch to the rear and withdrawing the magazine. On later models, the new type two-way release magazine catch release permits magazine removal with one hand, by pushing forward on the magazine release and withdrawing the magazine with the fingers of the same hand.

To prepare the gun for firing with a loaded magazine seated in the magazine guide, retract the action bar with the left forefinger, thus cocking the firing mechanism. When the action bar is fully retracted, remove the forefinger and allow the action bar to snap forward, thus loading and locking the piece. The piece may now be fired by depressing the trigger.

The rear sight is adjustable to ranges of 50, 100, 200, and 300 yards by raising the rear sight and sliding the elevator forward or back until the ears of the rear sight are able to engage in the desired cuts in the elevator.

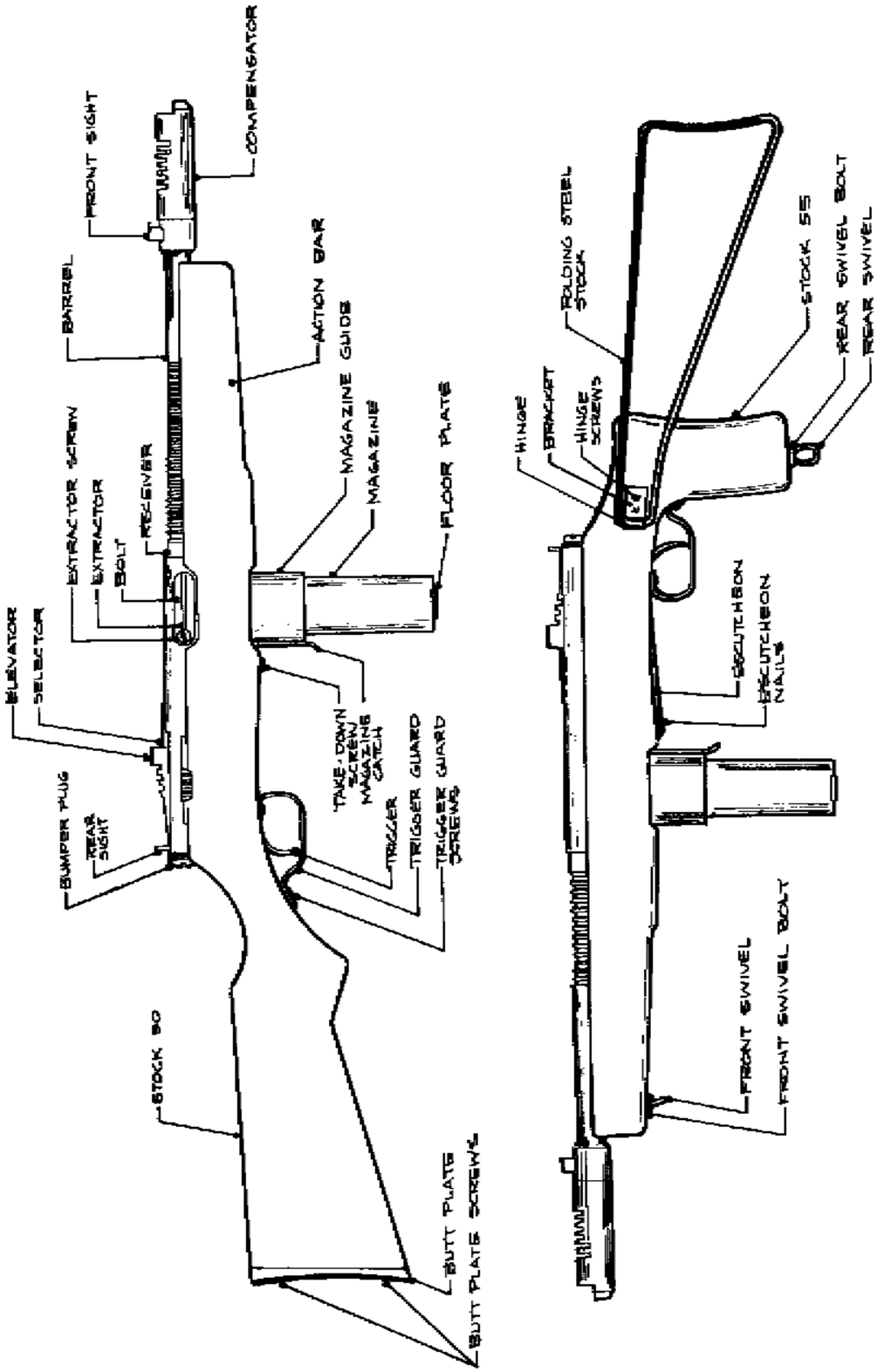


FIGURE 1

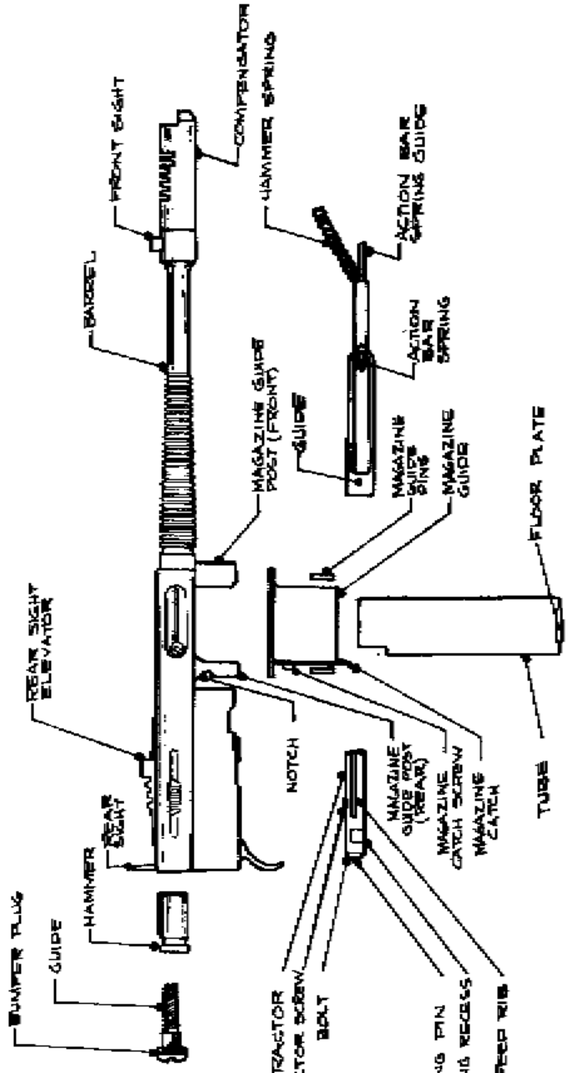
C. GENERAL DATA

(Lengths and weights are approximate)

(1) *Dimensions.*—

(a) Barrel:

Diameter of bore	inches	0.45
Number of grooves		6
Twist in rifling, uniform, right, one turn in	inches	16
Length of barrel, Model 50	do	11.00
Length of barrel, Model 55	do	10.50
Length of barrel, Model 60	do	18.00



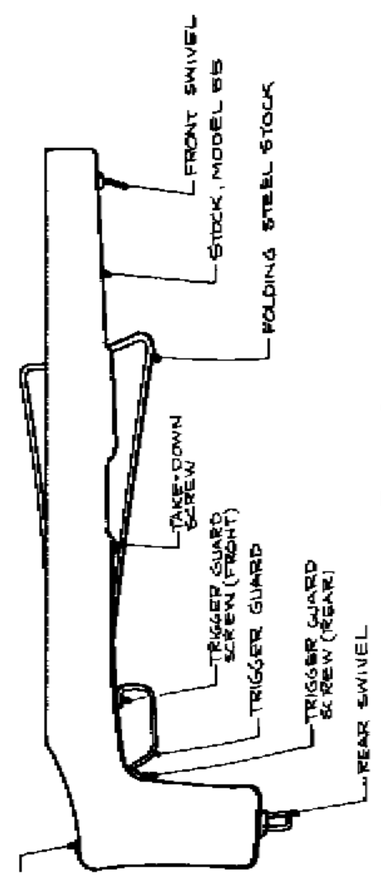


FIGURE 2.

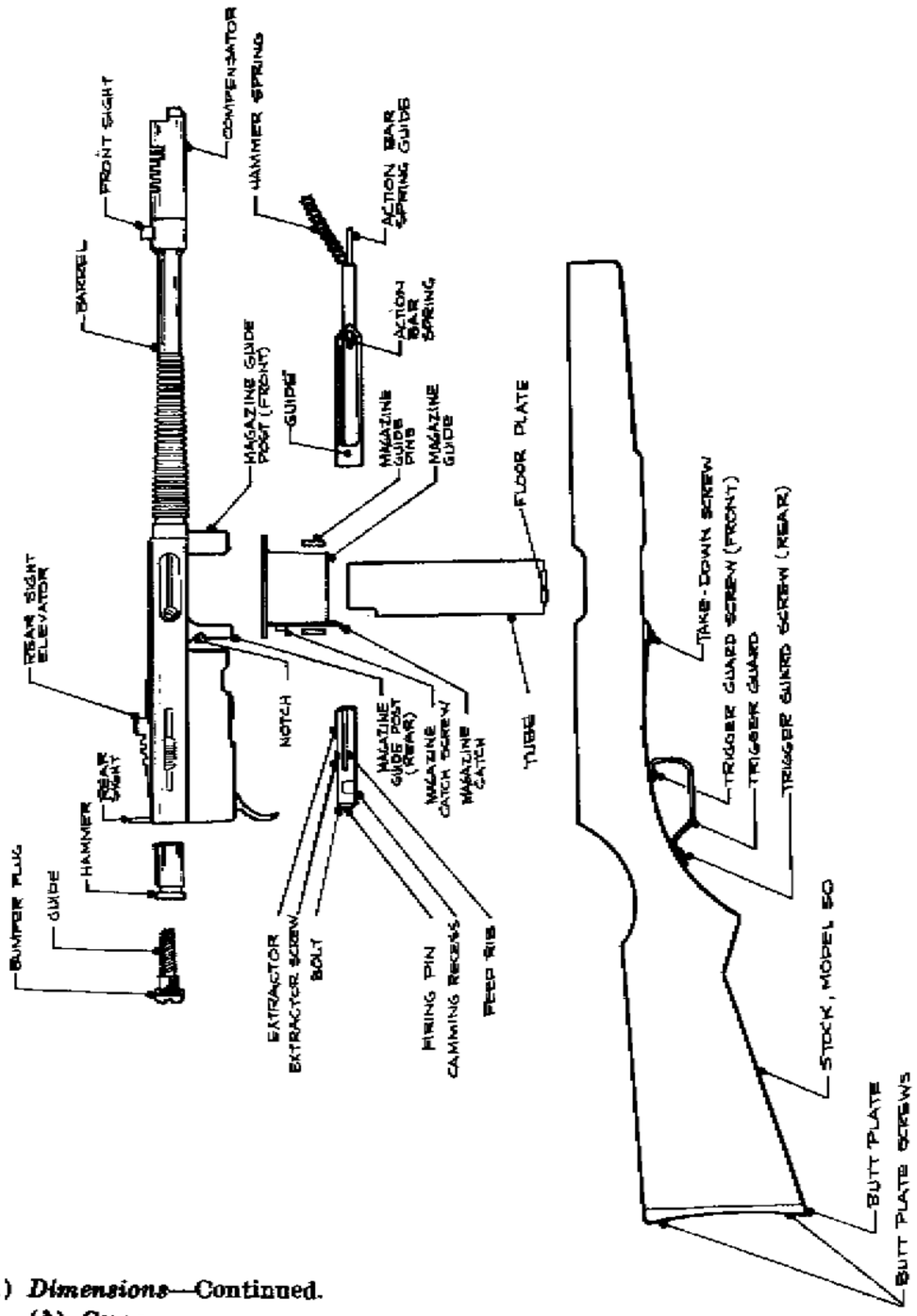


FIGURE 3.

(1) *Dimensions*—Continued.

(b) Gun:

Over-all length of Model 50, including compensator	inches	35.25
Over-all length of Model 55	do	22.25
Length of barrel and receiver w/o compensator, Model 55	do	19.00
Sight radius, Models 50, 55	do	18.00
Length of compensator	do	3.25
Sight radius, Model 60	do	25.00

(2) *Weights.*—

(a) Gun:

Model 50 w/o magazine	pounds	6.75
Model 55, w/o magazine	do	6.25
Model 60, w/o magazine	do	7.00

(2) *Weights*—Continued.

(b) Magazine:

Loaded 20-round magazine	pounds	1.40
Empty 20-round magazine	do	.35

D. MISCELLANEOUS DATA

(Approximate)

Initial velocity	feet per second	920
Pressure in chamber, pounds per square inch		12,000–16,000
Weight of cartridge, ball	grains	325
Weight of bullet	do	234
Weight of powder charge	do	5
Cyclic rate of fire, shots per minute		450–500

E. NOMENCLATURE OF COMPONENT PARTS

(1) *Submachine gun*—

1. Action Bar.
   - *a.* Camming lug.
   - *b.* Connector recess.
   - *c.* Fingerpiece.
   - *d.* Guide.
2. Action bar spring.
3. Action bar spring guide.
4. Automatic connector.
   - *a.* Hook.
   - *b.* Rear arm.
   - *c.* Stud.
5. Barrel.
6. Bolt.
   - *a.* Camming recess.
   - *b.* Feed rib.
7. Bumper plug.
   - *a.* Guide.
8. Bumper plug plunger.
9. Bumper plug plunger spring.
10. Compensator (Models 50, 60).
11. Connector plunger.
12. Connector plunger spring.
13. Disconnector.
14. Disconnector pin.
15. Disconnector spring.
16. Ejector.
17. Extractor.
18. Extractor screw.
19. Firing pin.

(1) *Submachine gun*—Continued.

20. Firing pin retaining pin.
21. Firing pin spring.
22. Front sight.
23. Front sight screw.
24. Hammer.
25. Hammer spring.
26. Magazine catch.

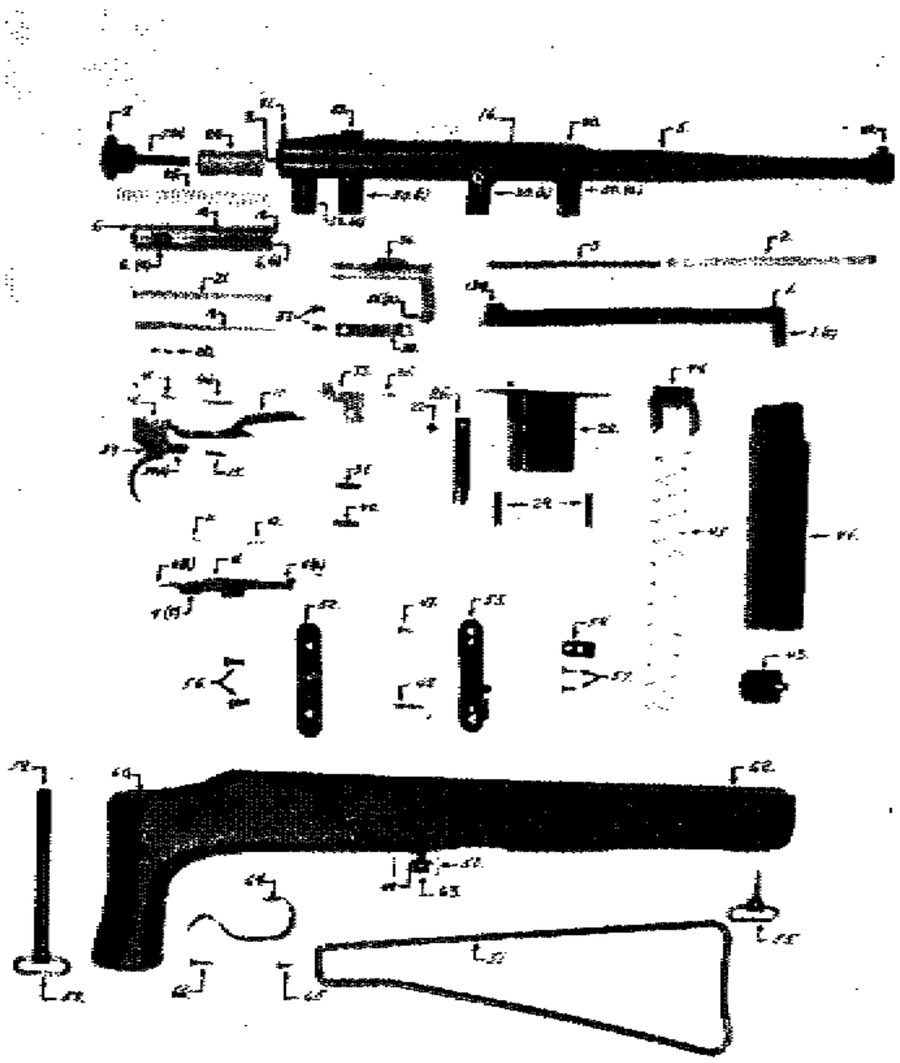


FIGURE 4.

27. Magazine catch screw.
28. Magazine guide.
    a. Magazine stop.
29. Magazine guide pins (2).

(1) *Submachine gun*—Continued.

30. Receiver.
    a. Magazine guide post, front.
    b. Magazine guide post, rear.
    c. Sear post.
    d. Trigger post.
31. Rear sight.
    a. Ears.
32. Rear sight elevator.
    a. Cuts.
33. Sear.
34. Sear pin.
35. Sear spring.
36. Selector.
    a. Extension.
37. Selector screws (2).
38. Selector spring.
39. Trigger.
    a. Extension.
    b. Stud.
40. Trigger pin.
41. Trigger plunger.
42. Trigger plunger spring.

Magazine:

43. Floor plate.
44. Follower.
45. Spring.
46. Tube.

Stock, Model 55:

47. Bracket screw, front.
48. Bracket screw, rear.
49. Escutcheon.
50. Escutcheon nails (2).
51. Folding steel stock.
52. Folding steel stock hinge.
53. Folding steel stock hinge bracket.
54. Folding steel stock latch.
55. Front swivel.
56. Hinge screws (2).
57. Latch screws (2).
58. Rear swivel.
59. Rear swivel bolt.
60. Rear swivel nut.
61. Rear swivel escutcheon.

(1) *Submachine gun*—Continued.
Stock, Model 55—Continued.
62. Stock, Model 55.
63. Take-down screw.
64. Trigger guard.
65. Trigger guard screw, front.
66. Trigger guard screw, rear.
Stock, Models 50 and 60:
67. Butt plate.
68. Butt plate screws (2).
69. Stock, Models 50 and 60.
70. Escutcheon.
71. Escutcheon nails (2).
72. Take-down screw.
73. Trigger guard.
74. Trigger guard screw, front.
75. Trigger guard screw, rear.

III. DISASSEMBLY AND ASSEMBLY

A. GENERAL

Disassembly is considered under two separate headings; *field disassembly* and *detailed disassembly*. Field disassembly entails such dismounting of the weapon as is necessary to facilitate *cleaning after firing*, and involves a minimum number of parts or groups of parts being removed from the weapon. Detailed disassembly is the complete disassembly of all demountable parts of the weapon and is done *only by competent qualified personnel* for purposes of inspection, adjustment, repair or replacement of parts.

B. FIELD DISASSEMBLY

Remove magazine by pressing magazine catch. After determining that the gun is unloaded, lay gun on table, barrel down, muzzle to left. Unscrew take-down screw and remove stock. Pull trigger to relieve tension of hammer spring. Unscrew bumper plug and remove hammer and spring, holding back on trigger. Push action bar to rear so that dismounting hole in action bar guide is visible. Insert end of hammer spring in dismounting hole. Push out magazine guide pins, use gun hammer if necessary, *right to left*. Remove magazine guide. (The magazine posts and magazine guide pins are tapered (No. 4 standard taper pin reamer). The magazine guide may be used as a screwdriver to remove bumper plug). *Set fire selector on F. A.*, hold up ends of connector and disconnector with forefinger of right hand and with left hand lift forward end of action bar to 90° angle. Using care so that no strain is put on connector

and disconnector, twist out action bar. Point muzzle up, pull trigger and bolt will drop out. The piece is now field disassembled.

NOTE.—*Do not change adjustment of Connector, Disconnector or Selector. (Magazine may be disassembled by removing floor plate.)*

C. FIELD ASSEMBLY

The procedure of disassembly is reversed for assembling. With trigger depressed, place bolt in receiver and slide it forward. Insert hammer, pull trigger, and hammer will fall on bolt. Lift ends of connector and disconnector and replace action bar, twisting it in under the ends of the connector and disconnector and laying it in place, action bar camming lug in bolt camming recess. Replace magazine guide and pins. Insert action bar spring guide in seat in post and remove hammer spring from dismounting hole. Replace hammer spring in receiver. Screw bumper plug into place. Replace stock and tighten take-down screw.

D. DETAILED DISASSEMBLY

Disassemble as in FIELD DISASSEMBLY. Relieve tension on trigger pin by pressing down trigger to receiver and push out trigger pin. Remove trigger and disconnector assembly. Relieve tension on sear pin and push out same. Remove sear and automatic connector. Unscrew selector screws and remove selector and selector spring. Push out firing pin, retaining pin from bolt and remove firing pin and spring. Do not remove extractor and extractor screw from bolt unless prepared to reset extractor screw to prevent its backing out during firing. Remove connector plunger and spring from sear post. Do not attempt to remove bumper plug plunger and spring from seat in receiver. Remove hammer spring from action bar spring guide allowing action bar spring and guide to be disassembled from action bar. Remove springs from sear, connector plunger, trigger plunger, and forward part of trigger (disconnector spring).

NOTE.—Do not remove extractor and extractor screw from bolt, except as noted above. Do not try to remove bumper plug plunger and spring from receiver.

E. DETAILED ASSEMBLY

Assembly is accomplished in reverse order. Replace trigger plunger and spring and disconnector spring in trigger. Replace connector plunger and spring in sear post, sear spring in sear, flatten end of sear spring out. Reassemble action bar spring and guide to action bar and insert end of hammer spring in dismounting hole of action bar spring guide, compressing action bar spring by placing finger piece of action bar against edge of table or similar

stop and pressing forward on action bar spring guide. Reassemble bolt. Replace selector on receiver, lay selector spring on selector and screw into place with selector screws. Lay connector stud in connector stud hole in sear and replace this assembly in sear post, securing with sear pin. Trigger and disconnector assembly is then replaced in trigger post and trigger pin inserted. Continue as in FIELD ASSEMBLY.

IV. CARE AND CLEANING

A. GENERAL

Although this weapon will generally function under extremely adverse conditions, it is necessary to give it proper care and treatment to ensure best results. The gun should be kept well cleaned and working parts lubricated with a light film of oil, or standard cleaner. After firing, the piece should be field disassembled and all parts cleaned which have come in contact with powder gases. *The face of the bolt and the firing pin should be cleaned. The firing pin spring is made of beryllium copper and is noncorrosive.*

B. BORE

Clean bore with warm soapy water when available or with standard cleaner. It is imperative that the bore be cleaned with either water or standard cleaner to dissolve the primer salts. Run cleaning brush through bore several times, pushing brush through bore all the way so that bristles of brush will reverse outside the bore each time. Run several wet patches through the bore. Dry out bore with clean patches until patches come out clean and dry. Run patch saturated with oil or standard cleaner through bore. *See that the compensator is not fouled by the cloth patch.*

C. CHAMBER

Special attention should be accorded the cleaning of the chamber when cleaning the bore.

D. EXTERIOR SURFACES

Wipe off dampness and dirt from exterior surfaces of gun with dry cloth. Wipe all metal surfaces with an oiled rag.

E. MAGAZINES

Magazines that have been exposed to use in the field should be disassembled and thoroughly cleaned and then wiped lightly with an oiled rag. DO NOT DRENCH THE MAGAZINES OR AMMUNITION WITH OIL.

F. LUBRICATION

This submachine gun has no provision for lubrication nor is there a need for it. A light film of oil on all working parts is sufficient lubrication; too much oil tends to slow down the mechanism.

V. FUNCTIONING

A. GENERAL

In order to simplify the explanation of functioning, the cycle has been divided into three phases, each of which is explained separately. These phases are: First phase, backward movement of recoiling parts; second phase, forward movement of recoiling parts; and, third phase, action of trigger mechanism.

B. FIRST PHASE

The first phase of functioning begins with the piece loaded and ready to fire. The hammer spring has been compressed and the hammer is held in a cocked position by the sear. *There are two notches in the hammer. The front notch functions in event of a weak powder charge.* Every shot in semiautomatic fire and each first shot of a burst of full automatic fire is fired through the direct action of the disconnector. When the trigger is pressed, the disconnector, which is assembled to the trigger, is caused to move forward, and since the disconnector is in engagement with the sear, the sear rotates on its pin and releases the hammer. The released hammer, under action of the compressed hammer spring, strikes the firing pin which transmits the blow to the primer of the chambered cartridge. Unless the bolt is in its fully locked position, the piece will not fire, for the firing pin will enter the hole in the hammer. The expanding gases, formed by the discharge of the cartridge, exert pressure against the face of the bolt, causing the bolt to unlock and move to the rear. The camming recess in the bolt, working on the camming lug of the action bar, moves the action bar rearward with the bolt, compressing the action bar spring. The bolt is cammed out of the locking shoulder in the receiver and the resistance of the action bar spring delays the overcoming of the inertia of the moving parts until the bullet has left the muzzle and chamber pressures have subsided. As the bolt moves to the rear, the extractor and residual pressure extracts the empty cartridge case which is cammed out through the ejection opening when the ejector comes in contact with the case. During this rearward action, the action bar cams the disconnector out of engagement with the sear, allowing the sear to engage the hammer under action of the sear spring. The hammer spring is compressed over the guide in the bumper plug. When pressure on the trigger is released, the disconnector engages the sear once more under action of the disconnector spring.

C. SECOND PHASE

The second phase of action is the forward movement of the action bar and bolt under the action of the compressed action bar spring. The feed rib of the bolt strips the top cartridge from the magazine and carries it into the chamber. The bolt, nearing its foremost position, is cammed up into the locking shoulder of the receiver by the camming lug of the action bar working in the camming recess in the bolt. The piece is now loaded and cocked, ready to be fired.

D. THIRD PHASE

(1) Selector set at "S. A." With the selector in this position, the extension of the selector holds the automatic connector out of the path of the action bar and the piece fires one shot each time the trigger is depressed as described in the FIRST PHASE.

(2) Selector set at "F. A." The first shot of any string of shots fired full automatic is fired through the action of the disconnector as described in the FIRST PHASE. Since the extension on the selector no longer prevents the connector from engaging with the action bar, and since pressure on the trigger has not been released, the hook of the connector rises into the connector recess in the rear of the action bar under the action of the connector plunger spring. When the bolt and action bar have gone almost completely forward into a locked position, the action bar exerts a pull on the connector, which, being attached to the sear, causes the sear to rotate on its pin and release the hammer, thus causing the piece to fire. This same action continues until the magazine has been emptied or the trigger released. Upon releasing pressure, the trigger, under action of the trigger plunger spring, rotates on its pin and the trigger stud bears against the rear arm of the connector, forcing the connector out of the path of the action bar. The disconnector then reengages the sear.

(3) Selector set at "Safe." At this setting the extension of the selector disengages the disconnector from the sear and prevents movement of the connector. The piece cannot be fired.

VI. STOPPAGES AND IMMEDIATE ACTION

A. IMMEDIATE ACTION IN MISFIRES

In the event of misfire, retract action bar smartly to eject misfired cartridge. Should round remain in chamber, allow action bar to snap forward and again attempt to fire.

B. IMMEDIATE ACTION IN OTHER STOPPAGES

(1) Retract action bar, set selector on "Safe," and allow empty case or cartridge to fall through ejection opening by turning gun right side down; reload, reset selector and resume firing.

(2) If gun still fails to function, change magazine, reload, and resume firing.

VII. SPARE PARTS AND ACCESSORY, SETS

The following parts and accessories are distributed for each 10 guns, Reising, submachine, caliber .45; (except as noted below).

1 catch, magazine, 50–29.
1 connector, automatic, 50–51.
1 disconnector, 50–10.
1 extractor, 50–14.
1 guide, retracting spring, 50–36.
1 pin, bolt, 50–4.
1 pin, disconnector, 50–12.
1 pin, firing, 50–16.
1 pin, magazine guide, 50–28.
1 pin, sear and trigger, 50–47.
1 plunger, trigger spring, 50–80.
1 plunger, automatic, connector spring, 50–79.
1 safety and fire control, 50–38.
1 screw, extractor, 50–15.
1 screw, magazine catch, 50–30.
1 screw, safety, 50–39.
1 screw, take-down (complete), 50–45.
1 sear, 50–41.
1 sight, front, 50–19, with screw, front sight, 55–15, assembled.
1 spring, disconnector, 50–11.
1 spring, firing pin, 50–17.
1 spring, hammer, 50–21.
1 spring, retracting, 50–37.
1 spring, safety, 50–40.
1 spring, sear, 50–42.
1 spring, trigger, 50–48.
1 spring, automatic connector, 50–52.
2 magazines, 20-round assembly, extra per gun.[1]

[1] 10 magazines per year are furnished to combat organizations.

1 brush, cleaning, Reising submachine gun, per gun.
1 chart, instructions, Reising submachine gun, per 50 guns, or fraction thereof.
1 pamphlet, Reising submachine gun, per 10 guns.
1 rod, cleaning, Reising submachine gun, per gun.
1 sling, strap, per gun.
1 case, 5-pocket, 20-round magazine (TSMG), per gun.[2]

VIII. SAFETY PRECAUTIONS

A. BEFORE FIRING

1. See that bore is clean and clear.
2. Work action bar several times to see that operation is smooth.
3. Try trigger mechanism on the settings of the selector.
4. Inspect magazines and eliminate faulty ones.
5. See that magazines are clean and properly loaded.

B. DURING FIRING

1. During target practice, insert loaded magazine only on order from range officer.
2. Set the selector at "Safe" while inserting the magazine.
3. Keep selector on "Safe" until gun is raised to fire.
4. Put finger on trigger only when gun is pointed at target.
5. Keep gun pointed at target while magazine is in gun.
6. Retract action bar about one-fourth inch to allow connector to disengage from action bar after the last shot has been fired "F. A."
7. To clear gun, remove magazine, see that no cartridge remains in the chamber, pull trigger and set selector on "Safe."

IX. INSPECTION, ADJUSTMENT, AND REPAIR

A. GENERAL

The adjustments and repairs, described in this section, should be performed only by Ordnance personnel or skilled gunsmiths.

It is important that this weapon be in proper adjustment to operate at its maximum efficiency. When all parts are in correct adjustment such stoppages as occur are usually due to faulty ammunition or improper lubrication (excessive or insufficient). The inspection for correct adjustment will be considered in regard to the position of the selector, each part being explained separately. Suggested remedies or repairs will follow each part.

Remove Stock before beginning inspection.

[2] 2 Cases, carrying 5-pocket type per gun, are furnished for combat organizations.

B. SELECTOR SET AT "S. A."

With barrel down, muzzle to left, work action bar with left hand, snapping trigger with right thumb. Work action bar several times. There should be no binding and a minimum of looseness and side-play. Bolt should lock fully. Pull trigger and note position of connector. The selector extension should hold the connector hook at least one-sixteenth inch from action bar. Cock piece and snap trigger, maintaining pressure on trigger. Recock and release trigger slowly. The disconnector should reengage the sear without hesitation. Forward tip of disconnector should lay on the action bar, holding disconnector slightly above sear shelf, yet allowing sear notch to engage with sear. Trigger extension should not foul disconnector.

Defects and remedies.—

Action bar binding	Shoulders of magazine guide posts are below level of side members of action bar. Peen shoulders to bring them above action bar. Dress with file.
Action bar loose (vertical play)	Shoulders of magazine guide posts are too high. Dress with file.
Action bar loose (lateral play)	Squeeze side members of action bar in vise to fit magazine guide posts.
Bolt does not lock	Inspect action bar notch in magazine guide post. Dress front part with file, if burred. Inspect locking shoulder for burrs or foreign matter.
Connector fouls action bar	Bend selector extension to lift connector.
Disconnector binds	Straighten disconnector. Smooth bearing surfaces of parts.
Disconnector tip away from action bar.	Insert rod forward of sear under disconnector to hold disconnector up. Strike tip of disconnector.
Disconnector not on sear	Fit disconnector to sear by filing notch deeper or cutting down nose.
Trigger extension fouls disconnector	Bend trigger extension to clear disconnector by clamping trigger in vise and striking extension a light blow.

C. SELECTOR SET AT "F. A."

Holding trigger back tightly with right thumb, drive action bar smartly to rear and allow to snap forward. Bolt should be in a fully locked position. Connector hook should be in connector recess in action bar. End of selector extension should not foul lug on connector. Trigger extension should not foul disconnector or connector. Rear of sear should not strike disconnector where attached to trigger. Sear should have forward play. Retract action bar and allow to move forward slowly, right thumb pressing trigger. Connector hook should not contact any part of action bar except rear of connector recess. Before action bar has gone forward enough for connector to engage in connector recess, release trigger and action bar simultaneously. Connector should not engage in action bar.

Defects and remedies.—

Bolt does not lock	Same as in "S. A."
Connector jumps out of action bar	Check for parts fouling or binding. Remove any burrs on connector hook, connector recess in action bar and action bar notch in magazine guide post. NOTE.—The radius filed at the bottom of the connector hook MUST be preserved. The common tapered file with its serrated edges is utilized at the factory.
Selector extension fouls connector lug.	Bend extension forward.
Rear of sear fouls disconnector	File clearance in disconnector.
Trigger extension fouls disconnector or connector.	Bend extension to clear.
Sear has no forward play in fired position.	Round front of sear.
Connector hook fouls section of action bar that enters action bar notch in magazine guide post.	File connector hook to clear.
Connector engages action bar, trigger being released.	Look for parts binding in trigger and sear mechanism.

D. SELECTOR SET AT "SAFE"

Selector should move easily yet with positive stops on settings. Clicks should be audible. Selector extension should cam disconnector out of engagement with sear, and block movement of connector as in "S. A."

Defects and remedies.—

Selector stiff	Ream out screw holes in selector spring.
Selector slides over settings	Remove selector spring and bend for more tension.
Clicks inaudible	Above remedy applies.
Selector jams on disconnector	Bend selector extension and smooth cam surface of disconnector.

E. SUMMARY

It can readily be seen that for the proper operation of the piece there can be no binding in the action from parts being out of adjustment and fouling each other. The mechanism should be adjusted correctly by Ordnance personnel or skilled gunsmiths before the gun is put into service, and with normal care this correct adjustment will be maintained.

Work carefully if it is found necessary to bend the selector extension as this part is case-hardened and liable to break. Should the selector break, the piece may still be fired, the type of fire being full automatic. Bursts of two or three shots may be fired with the weapon in this condition, the release of the trigger causing the immediate suspension of fire.

Should the connector be lost while cleaning in the field, the piece will fire semiautomatic only.

Although the extractor may be broken, the weapon may continue to extract and eject through the force of residual pressure as the bolt moves to the rear.

F. TABLE OF DEFECTS AND REPAIRS

[NOTE.—Repairs should be made by Ordnance personnel or skilled gunsmiths]

Set at—	Defect	Cause	Repair
S. A.	Failure to fire	Action bar binds	Peen up shoulders of magazine guide posts and dress evenly with file.
S. A.	do	Bolt does not lock	Dress with file front part of action bar notch in magazine guide post if burred. Remove foreign matter or burrs from locking shoulder in receiver.
S. A.	Fires full automatic.	Connector fouls action bar and engages with it.	Bend selector extension to lift connector.
S. A.	Fires 1 shot only	Disconnector binds; does not reengage sear.	Straighten disconnector and smooth bearing surfaces of parts.
S. A.	do	Trigger extension fouls disconnector.	Bend trigger extension to clear disconnector.
S. A.	Selector won't move to "Safe."	Selector jams on disconnector.	Bend selector extension to cam disconnector freely, and smooth cam surface of disconnector.
F. A.	Selector won't move to "Safe," piece not cocked.	Selector fouls on connector lug.	Retract action bar about ¼ inch to allow connector to disengage from action bar.
F. A.	Firing interrupted	Connector disengages from action bar.	Check for parts fouling or binding. Look for burrs on connector hook, connector recess in action bar, action bar notch in magazine guide post. Smooth burred parts.
F. A.	do	Selector extension fouls connector lug.	Bend extension forward.
F. A.	do	Connector hook fouls section of action bar that enters notch in magazine guide post.	File connector to clear.
F. A.	Uncontrolled fire	Connector engages action bar, trigger being released.	Check for parts fouling or binding in trigger and sear mechanism and correct.
Safe	Selector stiff	Screw holes too tight in spring.	Ream out screw holes in selector spring.
Safe	Selector loose	Selector spring weak	Remove selector spring and bend for more tension.
Safe	Clicks inaudible	do	Do.

NOTES—M55 PARACHUTE

(1) *To take up looseness of the folding stock and latch.*—Place butt end of wire stock on a flat surface and strike lightly with hammer on the inside surface. Try and repeat until correct. The latch should never be bent to take up any looseness.

(2) *Disconnector binding.*—(*assembled in stocks*).—Upon dismounting from stock, inspection of routing in stock, opposite the disconnector, may show the point which is rubbing. Trim excess wood with knife or wood chisel until action works freely.

(3) *In replacing the extractor screw.*—Check to see that the shank does not extend enough to bind the firing pin. Dress shank end of screw to correct this.

(4) *If the bolt should be held retracted or bind in the rearmost position* it may be temporarily corrected by loosening the bumper plug about one-half turn. As soon as practical, the bumper plug shank should be dressed back with a file and reduced about one-sixteenth inch for about one-half inch, or until binding is reduced. Cause: Bumper plug shank may be bent, and/or bumper plug threads in receiver may be out of line.

(5) The sights may be calibrated to a true zero at any desired range by filing down the front sight to raise the center of impact or by deepening the cuts in the elevator to lower the center of impact.

ANNEX NO. 1

LIST OF PARTS ARRANGED ACCORDING TO MANUFACTURER'S PIECE NUMBERS

50–1. Action bar.
50–2. Barrel.
50–3. Bolt.
50–4. Bolt pin.
50–5. Bumper plug.
50–6. Bumper plug plunger.
50–7. Bumper plug plunger spring.
50–8. Butt plate.
50–9. Butt plate screw.
50–10. Disconnector.
50–11. Disconnector spring.
50–12. Disconnector pin.
50–13. Ejector.
50–14. Extractor.
50–15. Extractor screw.
50–16. Firing pin.
50–17. Firing pin spring.
50–18. Compensator.
50–19. Front sight.
50–20. Hammer.
50–21. Hammer spring.
50–23. Magazine.
50–27. Magazine guide.
50–28. Magazine guide pin.
50–29. Magazine catch.
50–30. Magazine catch screw.
50–31. Rear sight.
50–32. Magazine catch release.
50–33. Rear sight elevator.
50–34. Receiver.
50–35. Receiver stud.
50–36. Retracting spring guide.
50–37. Retracting spring.
50–38. Safety & fire selector.
50–39. Safety screw.
50–40. Safety spring.

50–41. Sear.
50–42. Sear spring.
50–43. Take down screw lock washer.
50–45. Take down screw.
50–46. Trigger.
50–47. Trigger & sear pin.
50–48. Trigger spring.
50–49. Trigger guard.
50–50. Trigger guard screw.
50–51. Automatic connector (without lift pin).
(This number is assigned to this part until completed as an assembly.)
50–52. Automatic connector spring.
50–53. Escutcheon.
50–54. Escutcheon pin.
50–55. Retracting spring guide washer.
50–57. Automatic connector pin.
50–58. Automatic connector lift pin.
50–59. Magazine catch lock stud.
50–74. Strap (sling).
50–76. Swivel screw.
50–79. Connector spring plunger.
50–80. Trigger spring plunger.
50–81. Magazine guide stop pin.
50–87. Stock tie screw.
50–88. Stock tie screw nut.
50–90. Bumper plug stem.
50–91. Receiver stud filler washer.
50–92. Stock tie screw (front).
50–93. Trigger guard screw (rear).
50–94. Magazine catch lock stud.
50–301. Receiver assembly.
50–302. Rough assembly.
50–303. Finished assembly.
50–304. Magazine guide assembly.
50–305. Automatic connector assembly.
50–306. Bolt & firing pin assembly.
50–307. Disconnector & trigger assembly.
50–308. Magazine guide assembly.
50–309. Trigger & lift pin assembly.
55–2. Barrel.
55–3. Extractor spring clip.
55–4. Extractor hinge plate.
55–5. Extension butt clip.

55–6. Extension spring clip screw.
55–9. Sling screw for stock.
55–10. Stock reinforcement bolt head.
55–11. Stock reinforcement washer.
55–12. Extension spring clip screw (front).
55–13. Extension butt clip screw.
55–14. Extension hinge plate screw.
55–15. Front sight screw.
55–16. Stock extension.
55–17. Ext. hinge plate screw nut.
55–301. Receiver assembly.
55–302. Rough assembly.
55–303. Finished assembly keys or wrenches.

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